Each

Dart Aerospace Ltd. Wednesday, 12/13/2006 2:41:29 PM Kim Johnston User: **Process Sheet** : SPACER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 29922A **Estimate Number** : 10352 : D2280 :NIA **Part Number** P.O. Number S.O. No. : NA : D2280 REV D : 12/13/2006 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : NA First Issue Type : SMALL /MED FAB **Drawing Revision** : D : 28791A :NIA Material **Previous Run** : 1/5/2007 40 Um: **Due Date** Qty: Written By Checked & Approved By Comment JLM : Est Rev:A **Additional Product** Job Number: **Description: Machine Or Operation:** Seq. #: 1.0 M6061T6B0250X01000 6061-T6 Bar .25" x 1.0" Comment: Qty.: 0.2975 f(s)/Unit Total: 11.8986 f(s) Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000)Identify as D2280 Batch: M103039 2.0 SHEAR SHEAR Comment: SHEAR Cut blank: (3.400") +/-0.020" 3.0 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2280 and Dwg D2280 2-Deburr Then Tumble

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



40

4.0

5.0

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	 PAR #:	Fault Category: _	NCR: Yes No	DQA:	Date: 07/01/02
			QA: N/C C	losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B	Verification		Approval		
STEP	Section A			Sign & Date	Section C	Chief Eng	Approval QC Inspecto	
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C Section A Section C Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng	

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:29 PM User: Kim Johnston **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 29922A Part Number: D2280 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 QC3 POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>5+ 35</u> 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE CL 07/01/02 Job Completion

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector				
		•									
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQA	\:	_ Date:				

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification		Ameroval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29922A
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280 Rev: D		Page 1 of 1

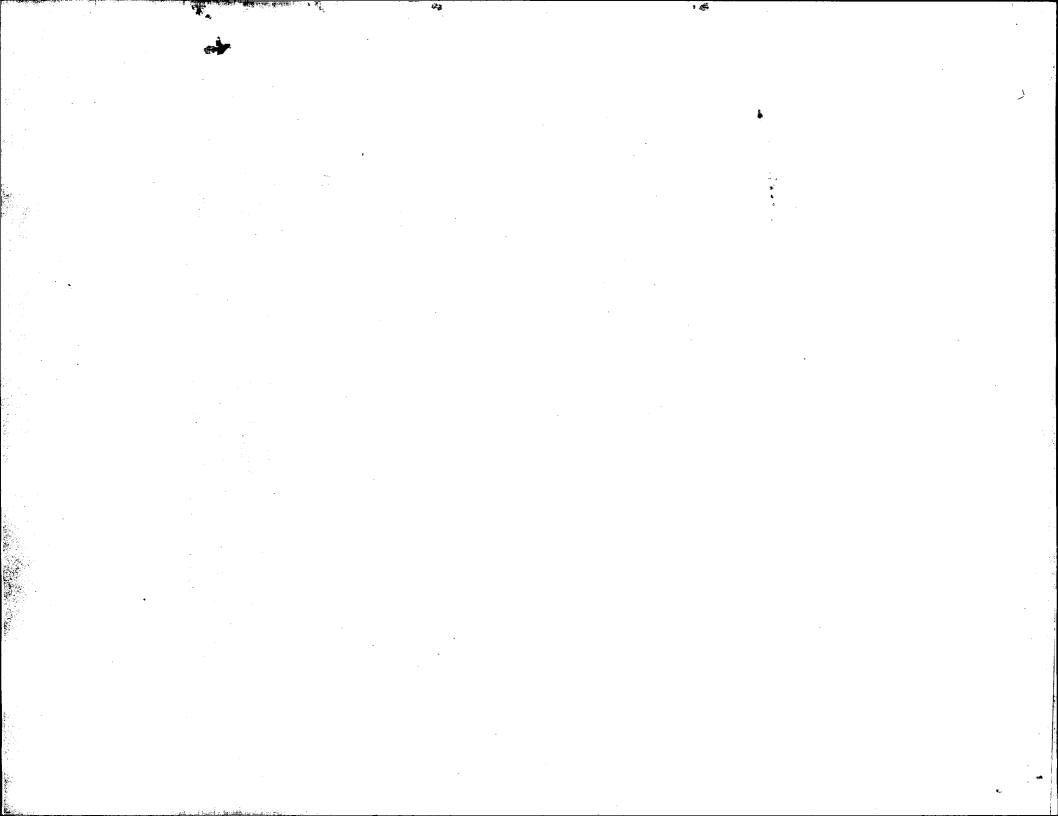
FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.150	+/-0.010	.144"			_	
0.236	+/-0.010	226"	1/			
3.270	+/-0.010	3,266"		,		
3.020	+/-0.010	3,015"				
2.135	+/-0.010	2.130	i			
1.135	+/-0.010	1.130"	V,			
0.250	+/-0.010	,245"	/			
1.00	+/-0.030	997"	/			
Ø0.128	+0.005/-0.000	Ø 131°				
Ø0.213	+0.005/-0.000	Ø.215"				
C'sink 0.250 x 90°	+/-0.010	240"				
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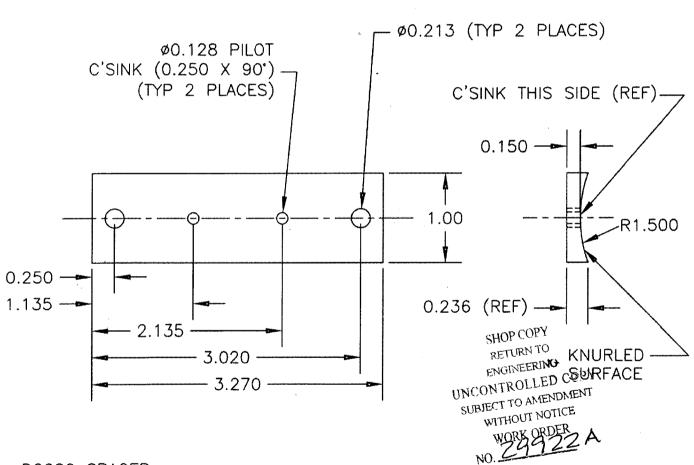
Measured by:	Audited by: 50	Prototype Approval:	N/A
Date: 06/12/22	Date: OC, 12, 22	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.12	New Issue P/O D2582	KJ/JLM	21
В	06.03.08	Dwg [*] Rev changed	KJ/JLM 🚓	
				





 DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK	(ED _M)	APPROVED	DRAWING NO. REV. D			
	#	#	D2280 SHEET 1 OF 1			
DATE			TITLE SCALE			
05.1	1.14		SPACER 1:1			
Α		94.10.14	NEW ISSUE			
В		95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20			
С		98.09.29	0.188 DIA HOLE CHANGED TO 0.213			
n		05 11 14	ADD FINISHING NOTE			



D2280 SPACER

- MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- ACID ETCH AND ALODINE PER DART QSI 005 4.1 2)
- ALL DIMENSIONS ARE IN INCHES 3)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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